

## ABSTRACT OF THE DISCLOSURE

A method including winding a first layer of a material about a mandrel, and bonding a second layer of a material to the first layer with a bitumen-based adhesive, wherein an active component of the bitumen-based adhesive is bitumen, and wherein at least one of the first and second layers comprises a lignocellulosic material. Another embodiment includes forming corrugated board by bonding a corrugated sheet to at least one outer sheet with a bitumen-based adhesive, wherein an active component of said bitumen-based adhesive is bitumen, and wherein at least one of said corrugated sheet and said outer sheet comprises a lignocellulosic material. Articles made according to the methods are also described.